

Date: Friday, 5/25/2007 8:16:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	32575		
Estimate Number	10950		
P.O. Number	N/A	Part Number	D2562005
This Issue	5/25/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2562 REV D
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	D
Written By		Material	N/A
Checked & Approved By	<u>JAD</u> 05.25.07	Due Date	6/5/2007
Comment	Est A 02.06.07 New Issue NG	Qty:	6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
	Comment: Qty.: 2.5374 f(s)/Unit Total : 15.2246 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch <u>1104640</u>	<u>FF 07-06-26</u>
2.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Punch to length as per Dwg D2562	<u>FF 07-06-26</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL/MED FAB RESOURCE 1-Bend end as per Dwg D2562 Angle "D" 2-Deburr	<u>SAP 07/07/05 ⑥</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<u>En 07/07/05</u>
5.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI-005 4.3	<u>m 101575</u>
		<u>BR / Sd. 07/07/05</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07K766
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 32575

Part Number: D2562005

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



07/7/06 (6)

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/7/06 (6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/06

Job Completion



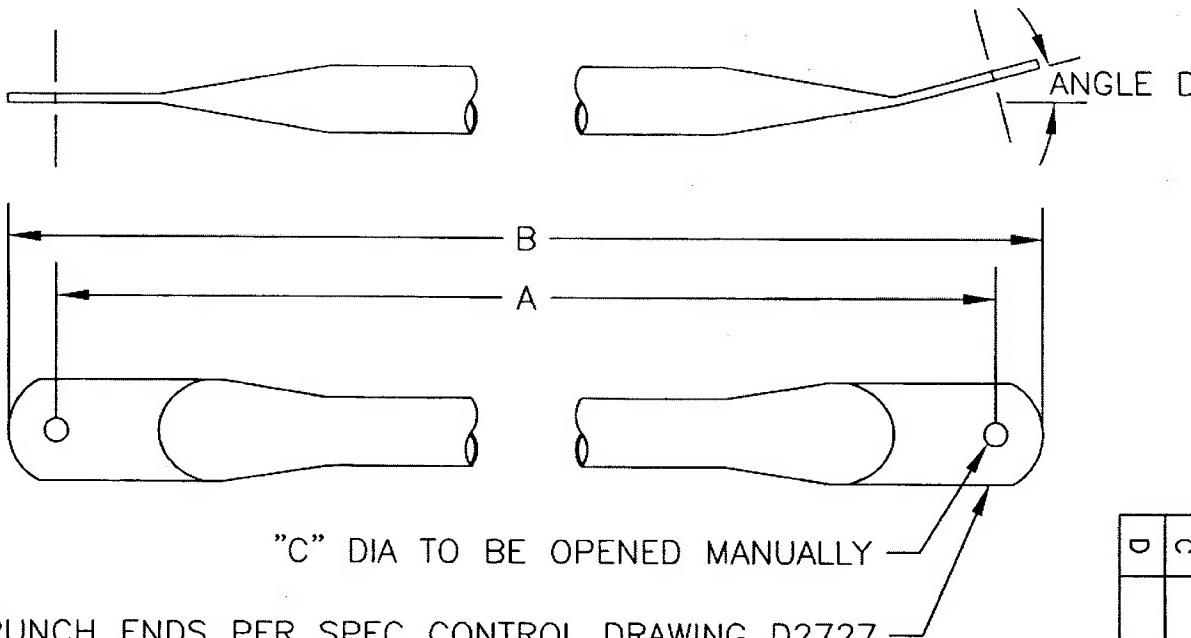
U 07.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	—	10
D2562-003	20.37	21.17	—	18
D2562-005	29.00	29.80	—	30
D2562-007	19.22	20.02	—	0
D2562-011	25.79	26.59	—	16
D2562-013	26.63	27.43	—	24

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WORK ORDER
NO 32515

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

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S.05.27

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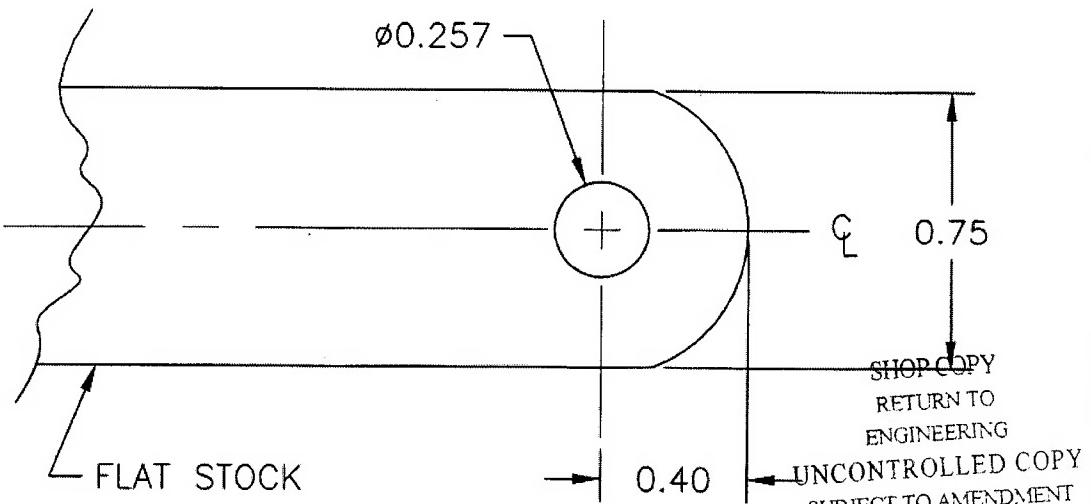
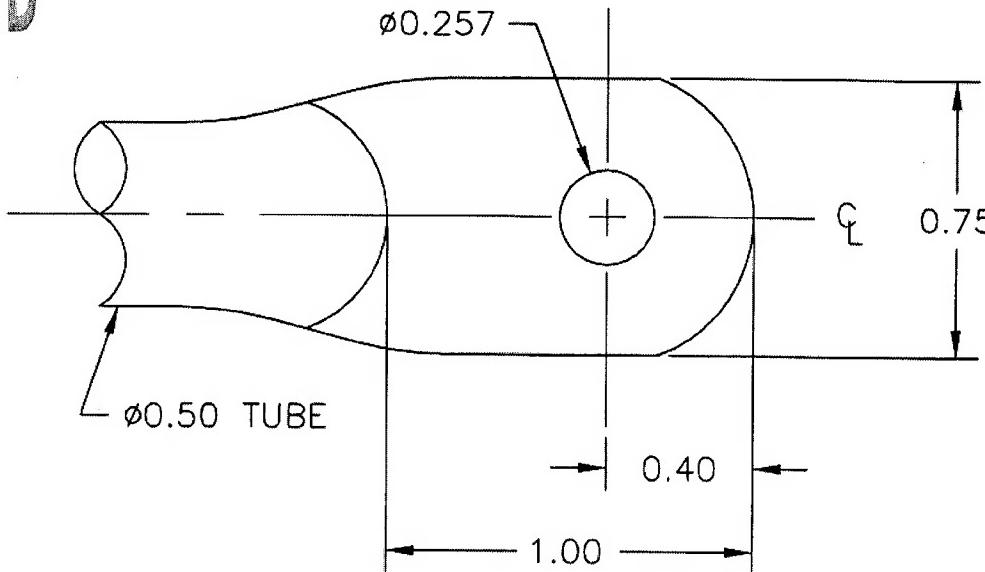
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HAWKESBURY, ONTARIO, CANADA

DART

DESIGN KE	DRAWN BY KF	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED JA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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